

Date: Tuesday, 8/1/2006 11:31:07 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE ASSEMBLY
Job Number	: 28075	Part Number	: D2873043
Estimate Number	: 11053	Drawing Number	: D2873 REVA
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 8/1/2006 S.O. No. : N/A	Drawing Revision	: A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 8/30/2006 Qty: 30 Um: Each
Previous Run	: 26409		
Written By	: [Signature]		
Checked & Approved By	: [Signature] 06.08.01		
Comment	: Est A05.09.13 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0375X01000	6061T6 BAR	
		Comment: Qty.: 0.3237 f(s)/Unit Total : 9.7115 f(s) 6061T6 BAR Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8) (M6061T6B0.375x01.000) Identify for D2873-3 Batch: M100742/11 pcs	J.F. 06/08/08 30
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 1.000" x 0.375" x 3.700" long	J.F. 06/08/08 30
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev A Folio Rev A	J.F. 06/08/09 30
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 06/08/09 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 8/1/2006 11:31:08 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 28075

Part Number: D2873043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JNL 06/08/10

30

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

ml 06/08/11 (30)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JNL 06-08-14 (30)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SC 06/08/14 (30)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

SB 06/08/21 (30)

10.0 MS20426AD46 Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 180.0000 Each(s)

Rivet

Pick;

Qty	Part Number	Description	Batch
6	MS20426AD4-6	Rivet	42930

11.0 MS21075L5 Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 90.0000 Each(s)

Nut Plate

Pick;

Qty	Part Number	Description	Batch
3	MS21075L5	Nut Plate	418136

SB 06/08/21 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1 Date: 06/18/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:31:08 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 28075

Part Number: D2873043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

SB 06/08/21

32

13.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

14.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST39D

AL 06/08/22 (2)

15.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06.08.23

Job Completion



204/08/22

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

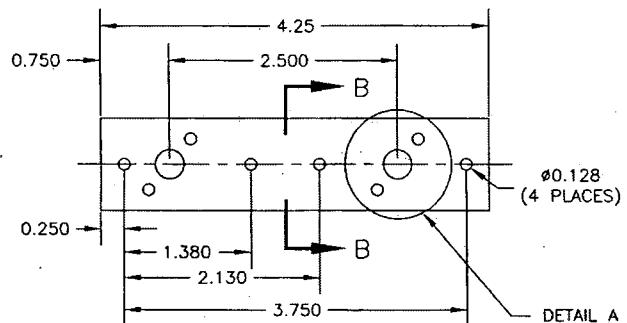
DART AEROSPACE LTD	Work Order:	28075
Description: NUT PLATE ASS.	Part Number:	02813-073
Inspection Dwg: 02873 , Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

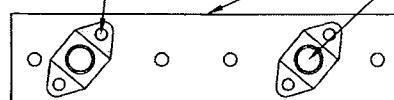
X First Article X Prototype

Measured by:	J.F.	Audited by:	J.G.	Prototype Approval:	S/A
Date:	06/08/09	Date:	06/08/09	Date:	

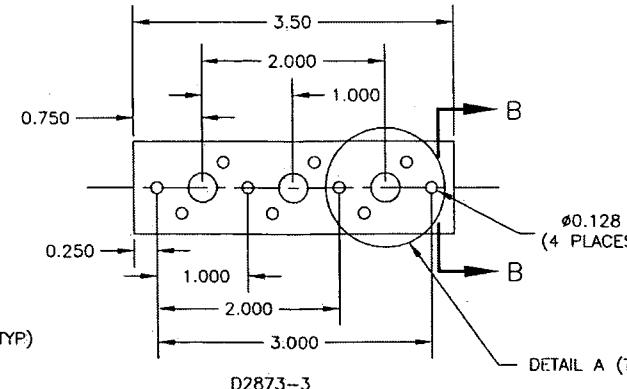
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D2873-1
RIVET (TYP 4 PLACES)



D2873-041

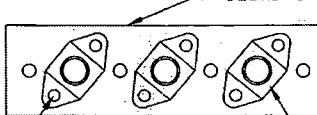


MS21075L5 NUT PLATE (TYP 2 PLACES)

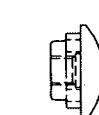
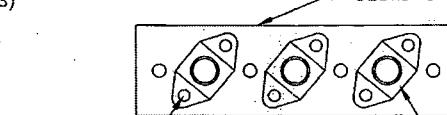


D2873-3

MS20426AD4-6
RIVET (TYP 6 PLACES)

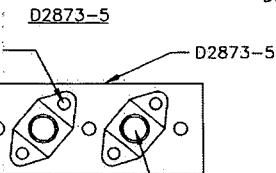


D2873-043

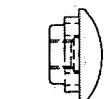


MS21075L5 NUT PLATE (TYP 3 PLACES)

MS20426AD4-6
RIVET (TYP 4 PLACES)



D2873-045



MS21075L5 NUT PLATE (TYP 2 PLACES)

D2873-1/-3/-5 RADIUS_BLOCK

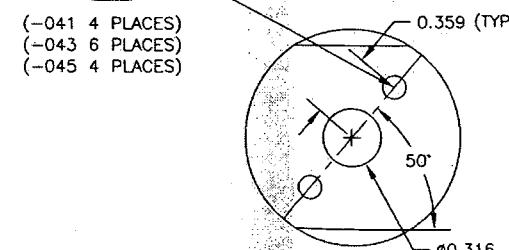
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\phi 0.128$ PILOT + C'BORE CURVED SIDE $\phi 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100^\circ$

D2873-041/-043/-045 NUT PLATE ASSEMBLY

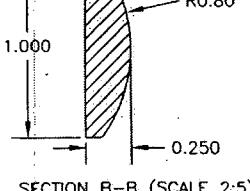
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
	X		D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
1			D2873-3	RADIUS BLOCK
1			D2873-5	RADIUS BLOCK
4	~6	4	MS20426AD4-6	RIVET
2	~3	2	MS21075L5	NUT PLATE



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

A	05.07.26	NEW ISSUE	
DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO.	REV. A
DATE	DATE	D2873	SHEET 1 OF 1
05.07.26	05.07.26	TITLE RADIUS_BLOCK	SCALE 4:5

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